

**Work Order ID 115648**

April-04-14 10:15:42 AM

**\*115648\***

Page 1

Item ID: D3453-3

Revision ID: ,

Item Name: Clevis

Start Date: 4/04/14 Start Qty: 16.00 **\*16\***Required Date: 4/04/14 Req'd Qty: 16.00 **\*16\***

Reference:

Approvals: Process Plan: MUSDate: 14-04-08

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Run

Start

**\*NR1\***

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Tooling:	Date:	Run	Start	Stop
--------------------------------	--------------------------	----------	-------	-----	-------	------

Draw Nbr	Revision Nbr	SPC (Y/N):	Date:
----------	--------------	------------	-------

100		0.00		<u>16</u>	<u>14/04/11</u>	<u>DAS</u>	<u>DAS</u>
-----	--	------	--	-----------	-----------------	------------	------------

**\*100\***

Doosan

Doosan Lathe

Memo

1-Turn as per Folio FA578

Rev: AA &Dwg D3453 Rev: b

2- Deburr as per dwg D3453

150

QC2- Inspect parts off machine FAI/FAIB

**\*150\***

QC

Quality Control

Memo

160

QC8- Inspect parts - second check

**\*160\***

QC

Quality Control

0.00		<u>16</u>	<u>14/04/11</u>	<u>DAS</u>	<u>DAS</u>
------	--	-----------	-----------------	------------	------------

0.00				<u>40</u>	<u>25</u>
------	--	--	--	-----------	-----------

				<u>9-89</u>	<u>9-89</u>
--	--	--	--	-------------	-------------

0.00		<u>16</u>	<u>14/04/11</u>	<u>DAS</u>	<u>DAS</u>
------	--	-----------	-----------------	------------	------------

0.00				<u>40</u>	<u>25</u>
------	--	--	--	-----------	-----------

				<u>9-89</u>	<u>9-89</u>
--	--	--	--	-------------	-------------

0.00	<b>DAS</b>	<u>14/04/13</u>	<u>16</u>	<u>0</u>	
------	------------	-----------------	-----------	----------	--

0.00	<b>44</b>	<u>9-89</u>			
------	-----------	-------------	--	--	--

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order:	<b>DISPOSITION</b>				<b>AGAINST DEPARTMENT/PROCESS</b>									
Part No.	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No.	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>									
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>									
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport														
Unapproved														
<b>FAULT CATEGORY</b>														
Landing Gear				<b>General</b>										
				<input type="checkbox"/> Bending	<input type="checkbox"/> Bend						<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Pressure/Forced
				<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route						<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance		<input type="checkbox"/> Set-up
				<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect						<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect		<input type="checkbox"/> Temperature/Cure
				<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs						<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing		<input type="checkbox"/> Weld
				<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination						<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved		<input type="checkbox"/> Wrong Stock Pulled
				<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink						<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong		<input type="checkbox"/> Other
				<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short						<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
				<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing						<input type="checkbox"/> Misread			
				<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes						<input type="checkbox"/> Off-set			
				<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish						<input type="checkbox"/> Out of Calibration			
				<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function						<input type="checkbox"/> Out of Sequence			

**Work Order ID 115648**

April-04-14 10:15:42 AM

**\*115648\***

Page 2

Item ID: D3453-3

Revision ID:

Item Name: Clevis

Start Date: 4/04/14 Start Qty: 16.00 **\*16\***Required Date: 4/04/14 Req'd Qty: 16.00 **\*16\***

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

170

Identify as per dwg & Stock Location: WA002**\*170\***

Packaging

Packaging

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

DAS

28

9-89

APR 14 2014

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Quality Control

Memo

\*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

0.00

MLJ 14-04-15  
MLJ 14-04-15

DQA: \_\_\_\_\_

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>				<b>DISPOSITION</b> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved		<b>AGAINST DEPARTMENT/PROCESS</b> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite						
<b>Root Cause</b> Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		Date	Step	Qty	<b>Description of work order update or non-conformance</b>		Initial Chief Eng	<b>Action Description</b>		Sign & Date	Verification	QC Inspector
<b>FAULT CATEGORY</b>												
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <hr/> <hr/> <hr/>		
<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other												

**Picklist Print**

April-04-14 10:15:41 AM

Page 1

Work Order ID: 115648

**\*115648\***

Parent Item: D3453-3

**\*D3453-3\***

Parent Item Name: Clevis

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 16.00

Required Qty: 16.00

Comments: A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased		No		100	f	26.6333	0.2452	3.9232		**	

**\*M304R1 250\***

304 round bar 1.250

Location	Loc Qty	Loc Code
MAT029	26.6333	
m126151	1.8	
m126647	12	
m128496	12.8333	412

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only

DART AEROSPACE LTD	Work Order:	115648
Description: Clevis	Part Number:	D3453-3
Inspection Dwg: D3453	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

DAS

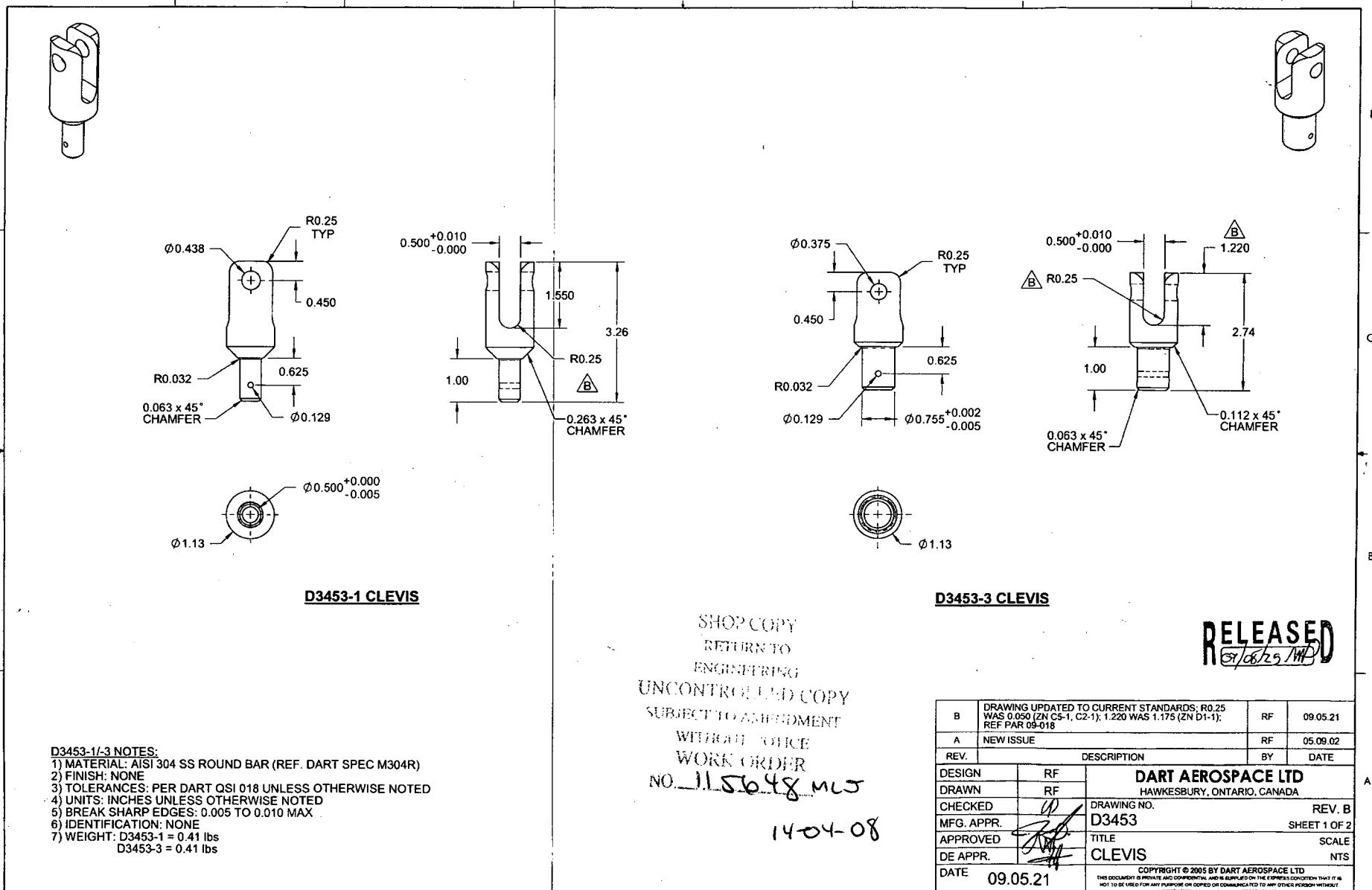
DAS

Measured by:	40 9-89	Audited by:	SD 9-89	Preliminary Approval:	
Date:	14/04/11	Date:	14/04/13	Date:	

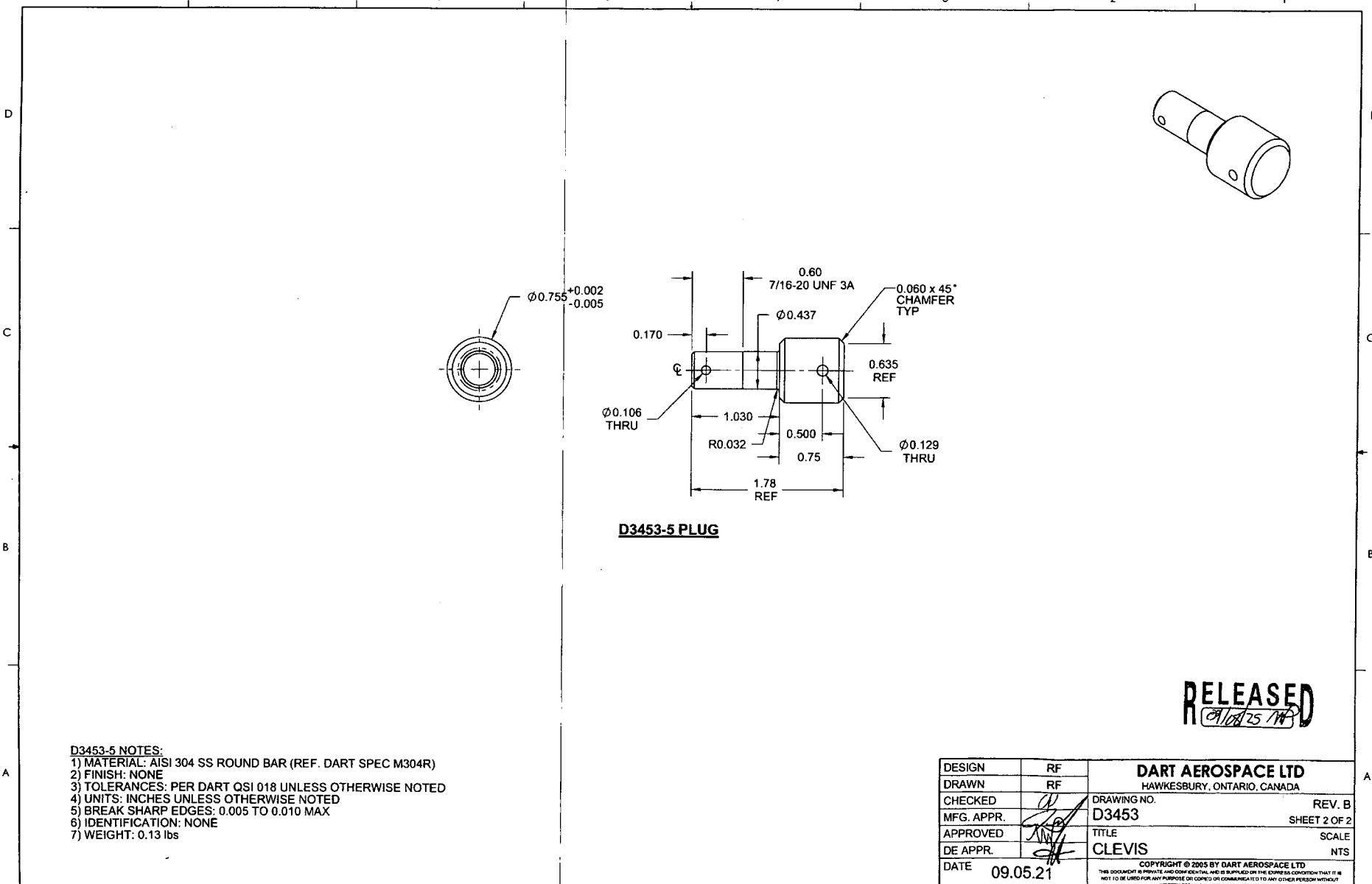
Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev B	KJ	
C	13.04.12	Tolerance updated for dimension Ø1.13	KJ	<del>JK</del> M

333  
60  
DRC

264  
P-20  
60  
DRC



8 7 6 5 4 3 2 1



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>W</i>	DRAWING NO.	
MFG. APPR.	<i>W</i>	REV. B	
APPROVED	<i>W</i>	D3453	
DE APPR.	<i>W</i>	SHEET 2 OF 2	
DATE	09.05.21	TITLE	SCALE
		CLEVIS	NTS

COPYRIGHT © 2005 BY DART AEROSPACE LTD  
THIS DOCUMENT CONTAINS TRADE SECRETS AND IS THE PROPERTY OF DART AEROSPACE LTD. IT IS  
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

A